



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4702
Job Sheet 171669



001521

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/18	0.00	0.00	Start Up Stores/Pkg-1		MLL
110	Small Fab	1 pcs		2/16/18	0.00	1.00	Small Fab-9		MLL DAB
120	QC	1 pcs		2/16/18	0.00	0.00	QC4	DAB 6	MAR 13 2018
125	DC	1 pcs		2/16/18	0.00	0.00	DC	6	MAR 13 2018
130	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-1	CKE132	MAR 13 2018
140	QC21-FG	1 Ea		2/16/18	0.00	0.00	QC21	DAB 21 8-89	MAR 14 2018

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7402

130 - Identify and pack for shipping as per PPP 648.4702

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	
600.1313	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	
AN4-16A	Bolt	3 Ea (3 ea)	90-Start up Operation	
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	
C2-3-1	Bearing DU	2 (2 ea)	90-Start up Operation	
C2-3-2-1	Roller Pin Retaining Ring	2 (2 ea)	90-Start up Operation	
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	
C2-3-5	Spacer, Teflon	2 (2 ea)	90-Start up Operation	
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-10-2	Lock Spring	1 Ea (1 ea)	90-Start up Operation	
C3-12-1	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-12-6 (5100-0037-SPP)	Lock Roller Retaining Ring	2 (2 ea)	90-Start up Operation	
C3-13-1 (06FDU04)	Keeper DU-Bearing Bushing	2 (2 ea)	90-Start up Operation	
C3-13-5 (DENDOFF)	Keeper Spring	1 (1 ea)	90-Start up Operation	
C3-3-4-1 (5100-0012-SPP)	Retaining Ring	4 (4 ea)	90-Start up Operation	
C3-3-9	Actuator Spring	1 (1 ea)	90-Start up Operation	
C3-4-1	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-7-1	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	
C3-7-2	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	
C3-8-4	Solenoid Cover Gasket	1 (1 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation											
				Completed By							
Root Cause											
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature ☐		Wrong ☐			
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Dimensions ☐			
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Der tolerance ☐			
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Die ☐		Correct ☐			
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection ☐		Lost/Missing ☐			
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Moved ☐			
Internal Transport ☐		Poor Information ☐		Crushing ☐		Counter ☐		N/A ☐			
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Tor ☐		ing ☐			
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instru ☐		read ☐			
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill ☐		ning Sequence ☐			
Past Expiry Date ☐		Manufacturing Process ☐									
Misidentified ☐		Past Due ☐		OTHER : _____							

Container No: S049212
Part: 648.4702
Serial No: 171669
Revision: 4
Inspector: _____
Date: 03/08/18
www.dartaerospace.com
Email: sales@dartaero.com
TEL: 1 613 632-5200
CANADA
Hawkesbury, ON K6A 1K7
1270 Aberdeen Street
DART Aerospace Ltd.

NAS1149F0463P	Washer	8 Ea (8 ea)	90-Start up Operation
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	90-Start up Operation
AN4-17A	Bolt	1 Ea (1 ea)	90-Start up Operation
MS21083N3	Nut	2 Ea (2 ea)	90-Start up Operation
NAS1149F0332P	Washer	2 Ea (2 ea)	90-Start up Operation
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	90-Start up Operation
NAS1149F0363P	Washer	1 Ea (1 ea)	90-Start up Operation
AN6-15A	Bolt	1 Ea (1 ea)	90-Start up Operation
MS21083N6	Nut	1 Ea (1 ea)	90-Start up Operation
NAS1149F0632P	Washer	2 Ea (2 ea)	90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	25	0
	188-FSCS-832-5/8	4	100	0
	600.1309-A	1	0	0
	600.1313	1	6	0
	AN4-16A	3	245	0
	AN4-17A	1	699	0
	AN6-15A	1	7	0
	C2-14-2	2	0	0
	C2-3-1	2	0	0
	C2-3-2-1	2	0	0
	C2-3-3-1	1	0	0
	C2-3-5	2	0	0
	C2-3-8	2	0	0
	C3-10-2	1	0	0
	C3-12-1	2	40	0
	C3-12-6 (5100-0037-SPP)	2	0	0
	C3-13-1 (06FDU04)	2	0	0
	C3-13-5 (DENDOFF)	1	0	0
	C3-3-4-1 (5100-0012-SPP)	4	0	0
	C3-3-9	1	0	0
	C3-4-1	2	0	0
	C3-7-1	1	0	0
	C3-7-2	2	0	0
	C3-8-4	1	0	0
	MS21044N4	4	39	0
	MS21083N3	2	100	0
	MS21083N6	1	30	0
	MS35266-63	1	50	0
	NAS1149F0332P	2	3,883	0
	NAS1149F0363P	1	285	0
	NAS1149F0463P	8	174	0
	NAS1149F0632P	2	60	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				